

Work Order ID 50870

July 23, 2009 9:45:08 AM



Page 1

Item ID: D3929-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: Gusset Assembly

Start Date: 7/24/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 7/28/2009 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: *W*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D3929

A

7

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

0.00

1-Cut as per Dwg D3929

Dwg Rev: *A*

Prog Rev: *A*

2-Deburr if necessary

HS 9-7-27



110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

HS 9-7-27

7

| W/O: | | WORK ORDER CHANGES | | | | | | |
|--------|------|---|----|----------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| 050805 | W/O | Add deng: Rev. to work order perm change | EC | 09.08.05 | | 090805 | 05.0805 | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
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NOTE: Date & initial all entries

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Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

130

Pick Kit

0.00

Packaging

Memo

0.00

Packaging

140

0.00

Large Fab

Memo

0.00

Large Fab

Weld bushings D3907-1 as per dwg D3929

316L rod batch: m109213

=> 80d4b7

(27)

6

P609.07.30

P609.07.30

| W/O: | | WORK ORDER CHANGES | | | | | |
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Work Order ID 50870

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Page 3

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Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location:

BASKET CELL

0.00



Packaging

Memo

0.00

Packaging

PD 09.07.30

PD 09.07.30

QC 09.07.30

7

7

7

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

Work Order ID 50870

July 23, 2009 9:45:08 AM



Page 4

Item ID: D3929-041

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Setup Start



Revision ID: A

Stop



Item Name: Gusset Assembly

Start Date: 7/24/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 7/28/2009 Req'd Qty: 6.00

Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
| 180 | QC21- Final Inspection - Work Order Release | 0.00 | 709-08-05 | | | | | | |
| | | | | | | | | | |
| QC | Memo | 0.00 | A | | | | | | |
| Quality Control | | | | | | | | | |

31-07-09

Y

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

July 23, 2009 9:45:08 AM

Page 1

Work Order ID: 50870

Parent Item: D3929-041RevA

Parent Item Name: Gusset Assembly


Comments:

Start Date: 7/24/2009

Required Date: 7/28/2009

Start Qty: 6.00

Required Qty: 6.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|----------------------------|----------------|--------|
| M304S11GA  | | Purchased | No | | | 100 | sf | 108.5733 | 2.8421 | | | |
| | | | | | | | | | | .4737/unit x 7 = 3.3159 | | |
| 304/316 0.125 Sheet | | | | | | | | | | | | |

Warehouse Loc Qty Loc Code
Location

Main Warehouse

MAT

108.5732632

111018

108.573263

D3907-1RevA

Manufactured

No

130

Each

8.0000

12.0000



Bushing

111018

B 9-7-07

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

8

50517

8

50944

14 p/09.07.30

(7)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

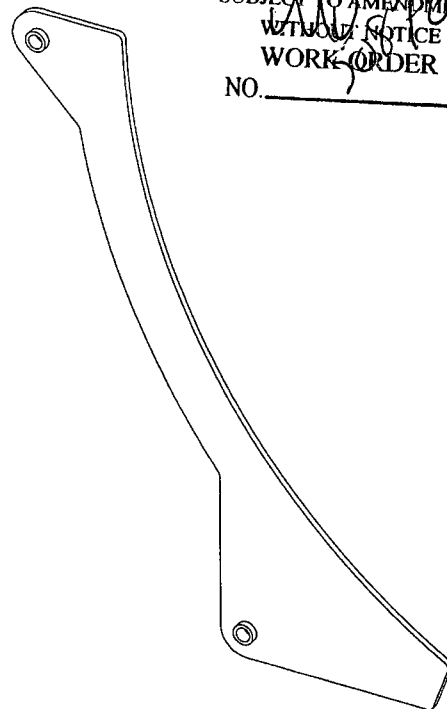
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

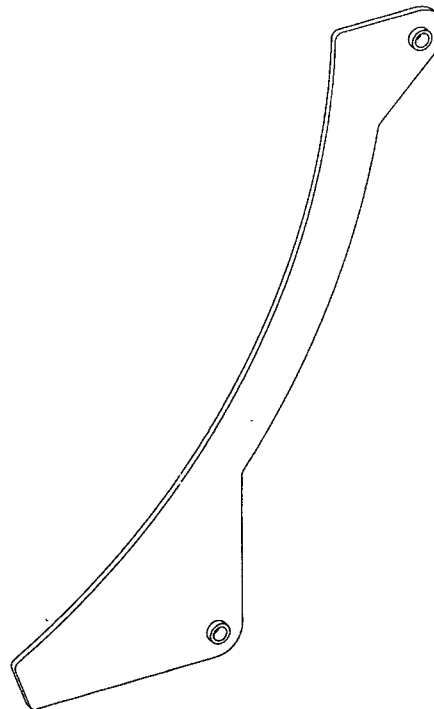
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WORK ORDER
NO. 102810



D3929-041 GUSSET ASSEMBLY



D3929-042 GUSSET ASSEMBLY

| ITEM | QTY -041 | QTY -042 | P/N | DESCRIPTION |
|------|-------------|-------------|-----------|-----------------|
| 1 | X | | D3929-041 | GUSSET ASSEMBLY |
| 2 | | X | D3929-042 | GUSSET ASSEMBLY |
| 11 | 2 | 2 | D3907-1 | BUSHING |
| 12 | 1 | 1 | D3929-1 | SUPPORT GUSSET |

RELEASED
07/04/12

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.73 lbs EACH
- 8) WELDING: PER DART QSI 004

| | | | |
|------------|-------------|----|----------|
| A | NEW ISSUE | MB | 09.04.03 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | | | |
| DRAWN | | | |
| CHECKED | | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 09.04.03 | | |

| | |
|---|------------------------|
| DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWING NO. D3929 | REV. A SHEET 1 OF 3 |
| TITLE GUSSET ASSEMBLY | SCALE NTS |
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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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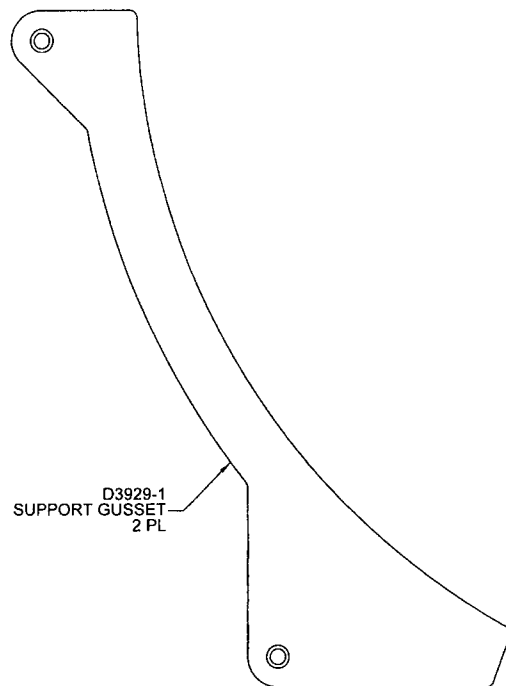
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

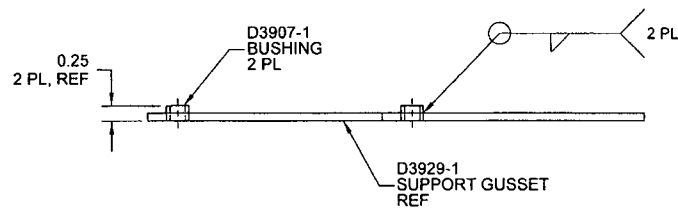
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WORK ORDER
NO. 50870



D3929-1
SUPPORT GUSSET
2 PL

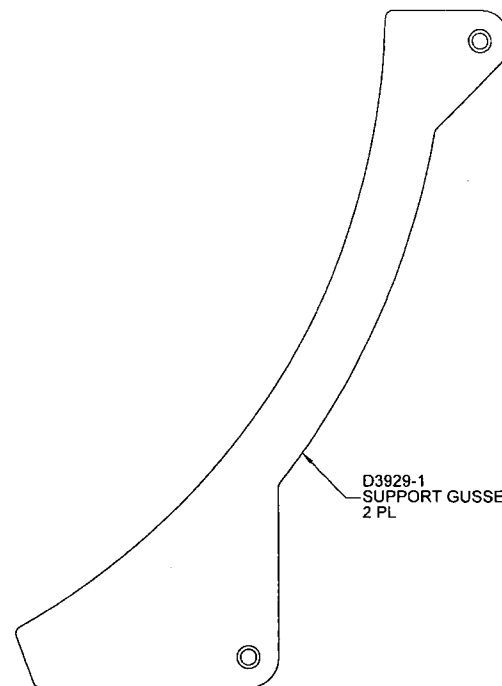


0.25
2 PL, REF

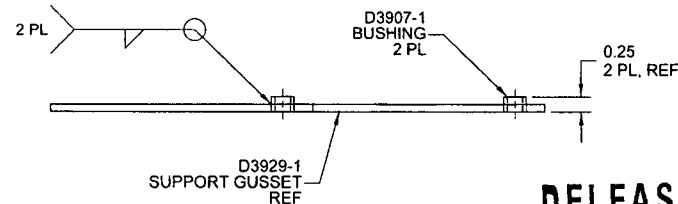
D3907-1
BUSHING
2 PL

D3929-1
SUPPORT GUSSET
REF

D3929-041 GUSSET ASSEMBLY



D3929-1
SUPPORT GUSSET
2 PL



0.25
2 PL, REF

D3907-1
BUSHING
2 PL

D3929-1
SUPPORT GUSSET
REF

D3929-042 GUSSET ASSEMBLY

RELEASED
09/04/22 MD

| | | | |
|------------|----------|---|--------|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. D3929 | REV. A |
| MFG. APPR. | | SHEET 2 OF 3 | |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | GUSSET ASSEMBLY | NTS |
| DATE | 09.04.03 | <small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small> | |

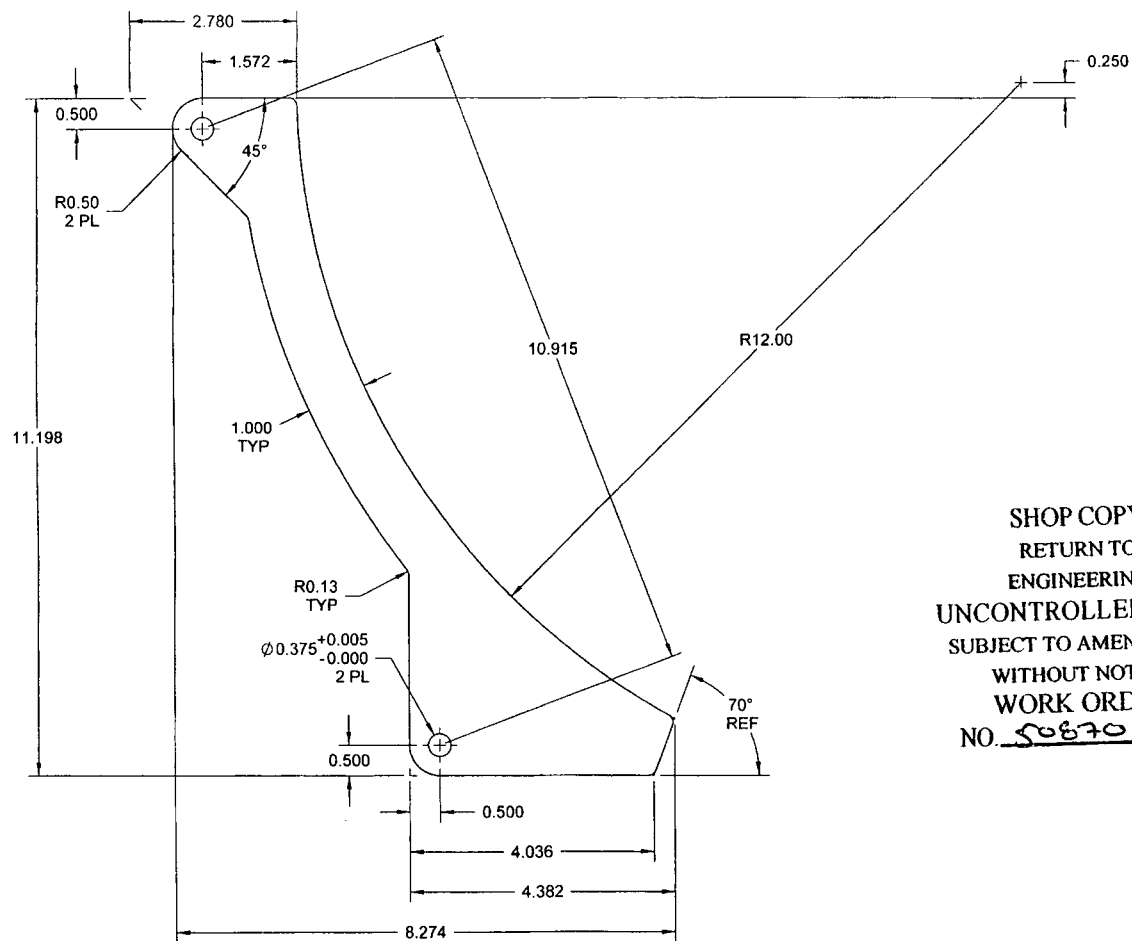
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NOTE: Date & initial all entries



D3929-1 SUPPORT GUSSET

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WITHOUT NOTICE
WORK ORDER
NO. 50670

RELEASED
09/04/22

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
11 GAUGE (0.125 THICK)
REF. DART SPEC. M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.72 lbs

| | | | |
|------------|----------|--|--------------|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | | D3929 | SHEET 3 OF 3 |
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